



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2583

Job Sheet 185951



Part No: D2583

Job Qty: 24 ea

Part Name: Latch Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP: C 00.11.01 Removed P/O for Powder Coat- in house process DM IPP: D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	24 pcs		11/28/18	0.00	0.60	Waterjet - Flow		SC 18/11/18
120	QC	24 pcs		11/28/18	0.00	0.00	QC8		38
130	Brake NC	24 pcs		11/28/18	0.01	0.74	Brake NC 1		38 B 18/11/18
140	QC	24 pcs		11/28/18	0.00	0.00	QC5		38
150	HandFinish	24 pcs		11/28/18	0.00	0.40	HandFinish1		DR 18/12/03
160	Powdercoat	24 pcs		11/28/18	0.00	0.29	Powdercoat1		DEC 18-12-03
170	QC	24 pcs		11/28/18	0.00	0.00	QC3		DAS DEC 03 2018 68
180	Packaging	24 pcs		11/28/18	0.00	0.00	Packaging3		DEC 03 2018 68
190	QC21-SA	24 Ea		11/28/18	0.00	0.00	QC21		DAS DEC 04 2018 21

Part Op 100 - 1-Cut as per Dwg D2583

Descriptions: 130 - Deburr Form on CNC Brake as per Dwg D2583

1138951 160 - START TIME: 2:20 TEMP: 320° FINISH: 2:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.040	5052-H32 .040 Sheet	2.8056 sf (.1169 ea)	100-Waterjet - Flow - 1	8070814

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.040	3	53	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Latch Bracket	3.380inches ± 0.010	3.390 3.370	3, 383	
2	Latch Bracket	0.907inches ± 0.010	0.917 0.897	0, 906	
3	Latch Bracket	1.725inches ± 0.010	1.735 1.715	1, 721	
4	Latch Bracket	0.125inches ± 0.010	0.135 0.115	0, 125	
5	Latch Bracket	0.980inches ± 0.010	0.990	0, 981	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date :		Step #:		MRB (QSI042) Approval	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S128525 Part: D2583 Job No: 185951 Serial No/Batch: S128525 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 11/15/18		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Environment Design Doc/Data Equip/Tooling Handling/Prep Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified		Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER :					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									